

# Work Order ID 66856

Tuesday, March 01, 2011 8:04:24 AM



Page 1

Item ID:	D3479-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Inlet Adapter					
Start Date:	3/1/2011	Start Qty: 2.00		Cust Item ID:		
Required Date:	3/7/2011	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>14</u>	Date:	<u>11-03-1</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3479	Rev B								
100		0.00							
	Small Fab								
Small Fab									
Small Fab	Memo	0.00							
	1-Assemble as per Dwg D3479								
	2-Spot Weld as per Dwg D3479 and Dart QSI 018								
110	QC11- Inspect spot weld per QSI004	0.00							
QC									
Quality Control	Memo	0.00							
120	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	Memo	0.00							

⇒ m-l 11/03/14

SB 11/03/14

SP 11/03/14

(2X)

(2)

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66856**

Tuesday, March 01, 2011 8:04:24 AM



Page 2

Item ID: D3479-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Inlet Adapter

Start Date: 3/1/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PMP 66856

0.00

Packaging

11/3/14 (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/14

mf

11-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, March 01, 2011 8:04:30 AM

Page 1

Work Order ID: 66856

Parent Item: D3479-041

Parent Item Name: Inlet Adapter



Start Date: 3/1/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 06-02-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3479-1 		Manufactured	No			100	Each	0.0000	1	2			
Tube							B 67125					m-l 11/03/11	
D3479-3 		Manufactured	No			100	Each	3.0000	1	2			
Tab, 99 degrees												m-l 11/05/11	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST063			3	B 67189		1			
				35162			2			1			
				46274			1			1			
D3479-5 		Manufactured	No			100	Each	2.0000	1	2			
Tab, 81 degrees												m-l 11/03/11	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST064			2	B 67190		2			
				35163			2						
D3479-7 		Manufactured	No			100	Each	2.0000	1	2			
Flange Plate												m-l 11/03/11	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST064			2						
				34090 ✓			2			2 X			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

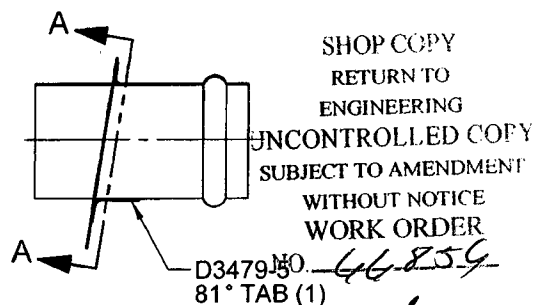
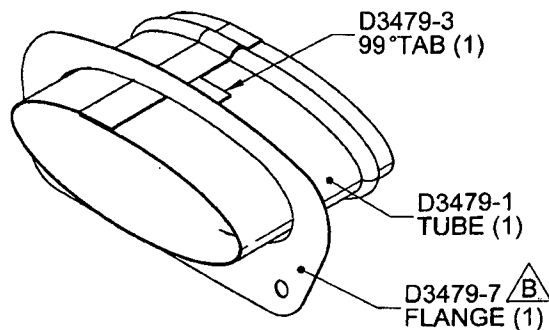
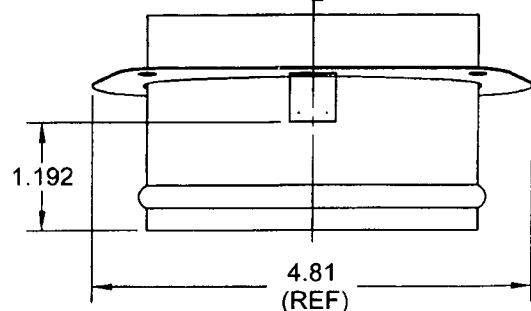
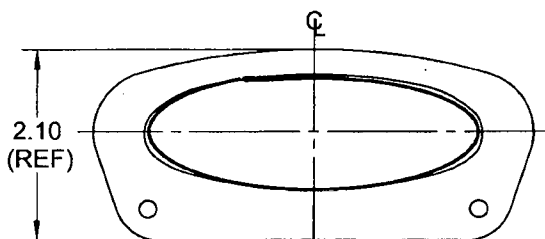
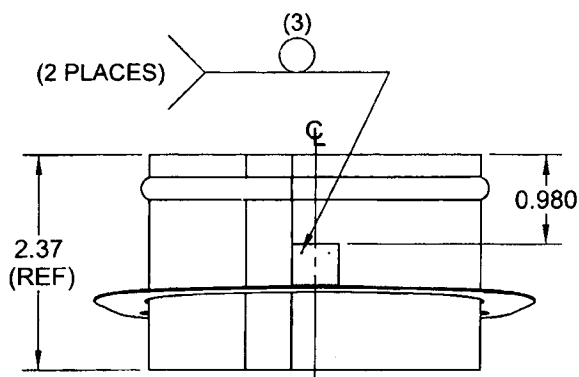
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



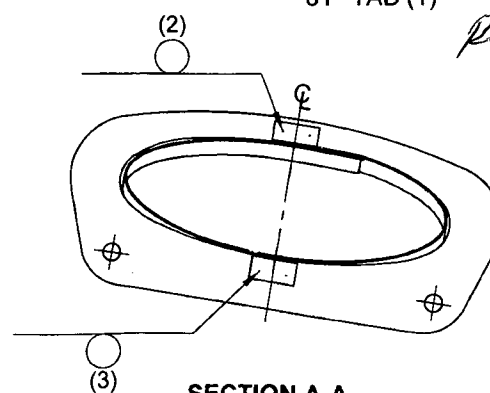
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3479</b>	REV. B SHEET 1 OF 4
DATE <b>08.12.19</b>		TITLE <b>INLET ADAPTER</b>	SCALE 1:2
A	06.01.19	NEW ISSUE	
B	08.12.19	CORRECT TYPO ON SHT1; ADD TOL ON SHT2; MATL SPEC WAS MIL-S-5019	

**RELEASED**  
*09/01/30 MJP*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. *46-859*  
*2/11-03-1*



## D3479-041 INLET ADAPTER

### NOTES:

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

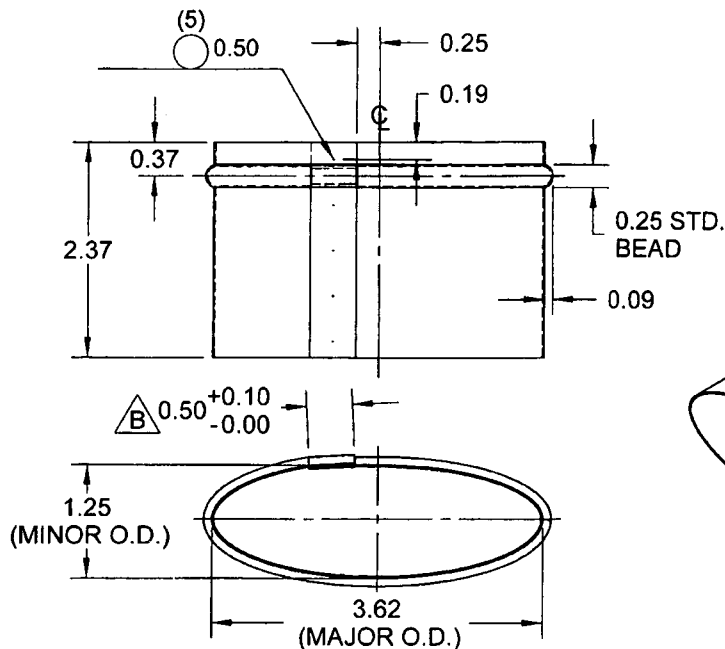
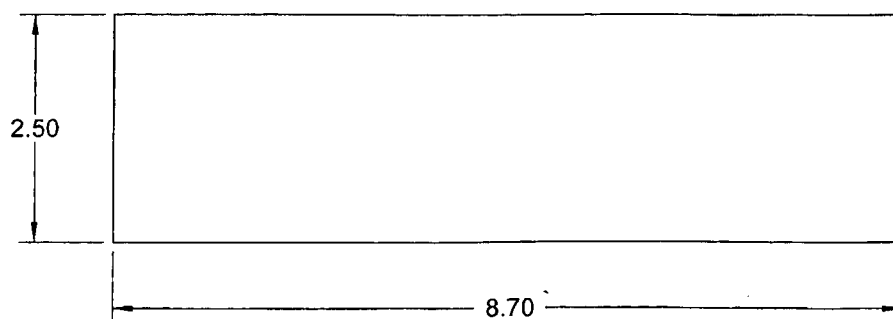
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>AA</i>	DRAWING NO. <b>D3479</b>	REV. B SHEET 2 OF 4
DATE <b>08.12.19</b>		TITLE <b>INLET ADAPTER</b>	SCALE 1:2

**RELEASED**  
09/01/2019**D3479-1 TUBE***w/o 66856***D3479-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\triangle B$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

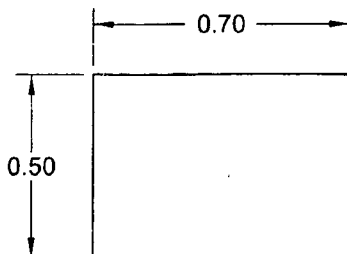
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



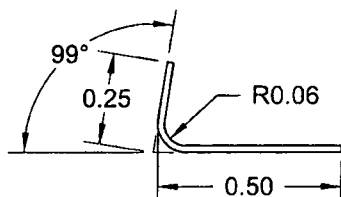
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3479</b>	REV. B SHEET 3 OF 4
DATE <b>08.12.19</b>		TITLE <b>ADAPTER INLET</b>	SCALE 2:1

**RELEASED**  
*09/01/30 MP*

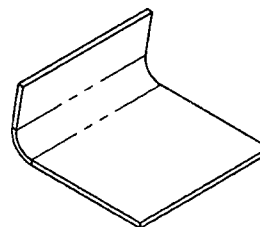


### **D3479-3F FLAT PATTERN**

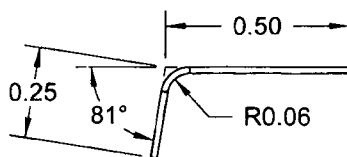
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\triangle_B$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)



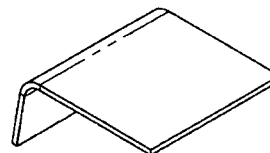
### **D3479-3 99 DEGREE TAB** (MAKE FROM D3479-3F FLAT PATTERN)



*also 64854*



### **D3479-5 81 DEGREE TAB** (MAKE FROM D3479-3F FLAT PATTERN)



### **NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

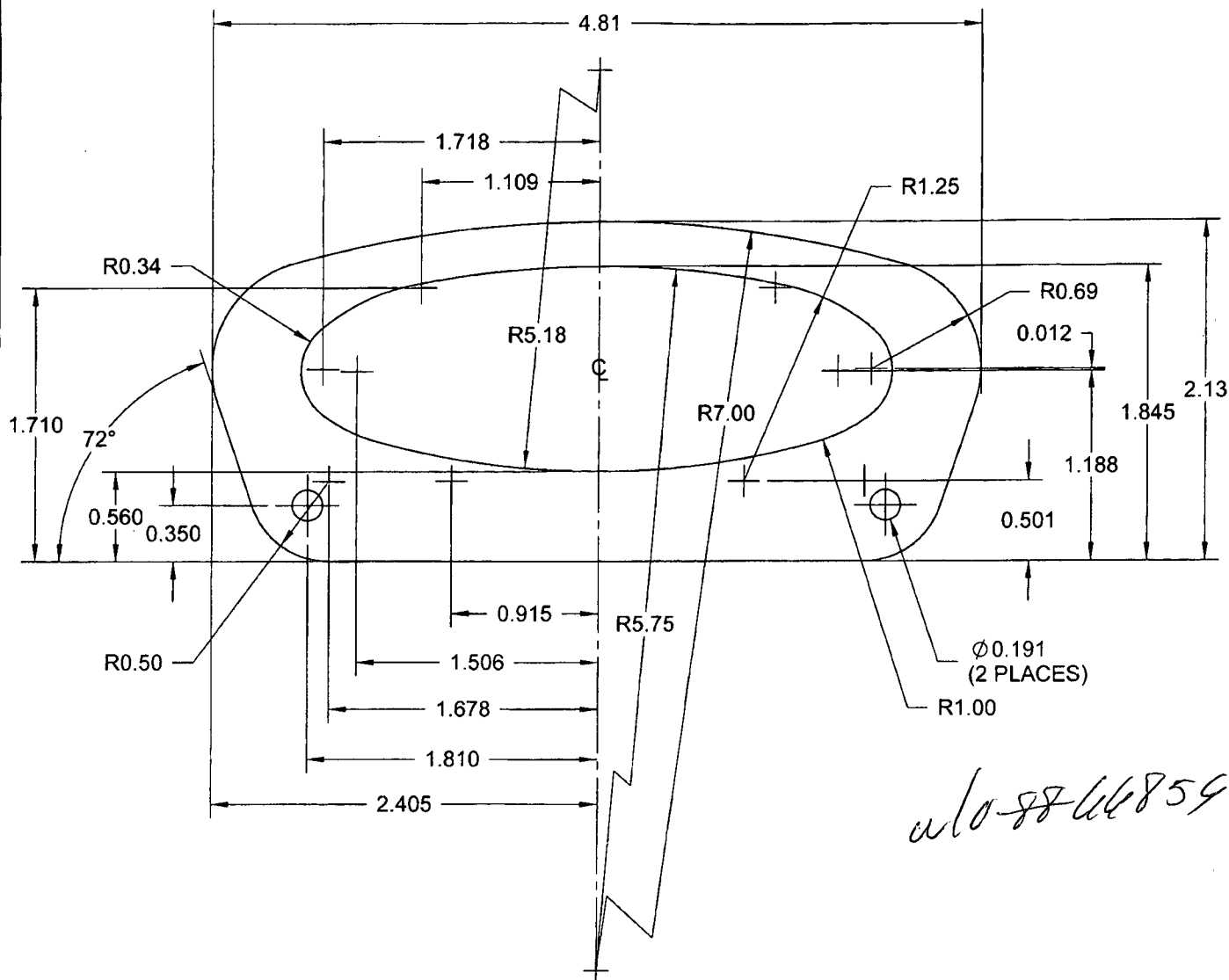
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN ↓	DRAWN BY ↓	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RA</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3479</b>	REV. B SHEET 4 OF 4
DATE <b>08.12.19</b>		TITLE <b>ADAPTER INLET</b>	SCALE 1:1

**RELEASED**  
*9/6/30 MP***D3479-7 FLANGE PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\triangle B$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO: 97

EMPLOYEE: Marc Gregory

PART NUMBER: D3479-041

JOB NUMBER: 66856

MATERIAL TYPE: 304

MATERIAL THICKNESS: .018

GROUP SPECIFICATION: SS

Group 1: Aluminum & magnesium

Group 2: Iron; nickel; cobalt

Group 3: Titanium SS

## TEST RESULTS

PASS FAIL

VISUAL: [ ☒ ] [ ☐ ]

PENETRATION: [ ☒ ] [ ☐ ]

PULL STRENGTH: [ ☒ ] [ ☐ ] PSI Reading: \_\_\_\_\_

The individual named above has been trained and is qualified in accordance with standard AMS-W-6858A, and QSI 004 ( ref: 4.3 )

DATE OF TEST COUPON: 11/03/14

QUALIFIER: SB